

**Work Order ID 70804**

Wednesday, June 15, 2011 12:36:21 PM



Page 1

Item ID: D212-664-207TRN

Accept



Setup Start

Revision ID: ~~U/R~~

Item Name: Crosstube Turning Detail

Stop



Start Date: 6/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *P*Date: *11-06-15*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D212-664-247	Rev B <del>U/R</del> <i>OK</i> <i>11.06.16</i>

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA706  
2-Turn first side as per Folio FA706  
3- File transition lines smooth.

*1* *Ø*  
*MAN. L 11/08/26*

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

*1* *Ø*  
*MAN. L 11/08/26*

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA706  
2- File transition lines smooth.  
3-Remove sand and plugs

*1* *Ø*  
*MAN. L 11/08/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Install supports using process per the instructions of the attached email					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70804**

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Page 2

Item ID: D212-664-207TRN

Accept

Revision ID: U/R

Item Name: Crosstube Turning Detail

Start Date: 6/15/2011 Start Qty: 1.00

Required Date: 6/17/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC1- Inspect dimensions to dimension sheet

0.00



QC

Memo

0.00

Quality Control

M.M.V 11/08/26

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11-8-31

150

Crosstubes Chemical Conversion

0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

21 11-08-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 70804**

Wednesday, June 15, 2011 12:36:21 PM

Page 3

Item ID: D212-664-207TRN

Accept

Revision ID: U/R

Item Name: Crosstube Turning Detail

Start Date: 6/15/2011 Start Qty: 1.00

Required Date: 6/17/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-9-1

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack  
Location: 46

11-9-1

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/16

mf  
11-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, June 15, 2011 12:36:27 PM

Page 1

Work Order ID: 70804



Parent Item: D212-664-207TRN



Parent Item Name: Crosstube Turning Detail


Start Date: 6/15/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec  
IPP Rev B 08.04.02 Removed polish EC verified DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6008-132 		Manufactured	No			110	Each	13.6500	1	1			

Crosstube extrusion

Location

LG

50892

57660

58414

Loc Qty

13.65

2.65

3

8

Loc Code

1

DFB 11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 70804
<b>Description:</b> Crosstube Assembly (205/212 Low Aft)	<b>Part Number:</b> D212-664-247
<b>Inspection Dwg:</b> D212-664-247 Rev: B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.438	+/-0.010	0.438	✓		vern	CWC-08
	2.680	+0.005/-0.000	2.685	✓		mic	CWC-04
	2.680	+0.005/-0.000	2.685	✓		"	
	2.687	+0.005/-0.000	2.692	✓		"	
	2.802	+0.005/-0.000	2.806	✓		"	
	2.906	+0.005/-0.000	2.907	✓		"	
	3.009	+0.005/-0.000	3.014	✓		mic	CNC-05
	3.112	+0.005/-0.000	3.116	✓		"	
	3.250	+0.005/-0.000	3.250	✓		"	
SIDE B	0.438	+/-0.010	0.438	✓		vern	CWC-08
	2.680	+0.005/-0.000	2.685	✓		mic	CWC-04
	2.680	+0.005/-0.000	2.685	✓		"	
	2.687	+0.005/-0.000	2.692	✓		"	
	2.802	+0.005/-0.000	2.806	✓		"	
	2.906	+0.005/-0.000	2.907	✓		"	
	3.009	+0.005/-0.000	3.013	✓		mic	CNC-05
	3.112	+0.005/-0.000	3.114	✓		"	
	3.250	+0.005/-0.000	3.250	✓		"	
	128.268	+/-0.030	128.260	✓		tape	mm.-02

<b>Measured by:</b> mmc	<b>Audited by:</b> DP	<b>Preliminary Approval:</b>	N/A
<b>Date:</b> 11/08/25	<b>Date:</b> 11-8-31	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.07	New Issue (P/O D212-664-207)	KJ/EC	
B	10.04.01	Dwg Rev updated	KJ	
C	10.08.03	Dimension 128.268 was 128.27	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Item	Qty -247	Qty -247B	Part Number	Description
1	X		D212-664-247	CROSSTUBE ASSEMBLY (205/212 LOW AFT)
2		X	D212-664-247B	CROSSTUBE ASSEMBLY (214 LOW AFT)
3	1	1	D6008-132	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	2	2	D3660-1	CUFF
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	44	44	CR3212-4-06	RIVET (OR M7885/3-4-06)
9	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
10	A/R	A/R	SIKAFLEX-241/-291	SEALANT (OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6008-132  
FINISHED LENGTH = 128.268±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF  
USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-247 = 36.6 lbs (PER IIN-D212-664)  
D212-664-247B = 36.6 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) WHEN MACHINING TAPER, RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD  
BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6%  
BASED ON O.D., EXCEPT UP TO 10% IS ALLOWED IN AREA NOTED.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF  
D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER  
INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1  
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE  
SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.  
DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE  
UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS  
NOT BOTTOMED-OUT AFTER TORQUING.
- 16) INSTALL D3660-1 CUFF AFTER CHEMICAL CONVERSION COAT BUT BEFORE PAINT, WITH A LAYER OF  
SIKAFLEX-241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT BETWEEN CUFF AND CROSSTUBE.  
SEAL EDGE OF CUFF TO ENSURE NO GAPS.
- 17) TOUCH-UP HOLES WITH CHEMICAL CONVERSION COAT.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 10804

*11-06-15*

UNDER REVIEW

*11.06.13*

**RELEASED**  
2009-10-29  
*MP*

B	REVISE GENERAL NOTES/PART LIST; UPDATE TO CURRENT STANDARDS; ADD -247B (ZN C4-2, D5-2)	RF	09.09.30
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>MP</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MP</i>	D212-664-247	SHEET 1 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	CROSSTUBE (205/212 LOW AFT)	NTS
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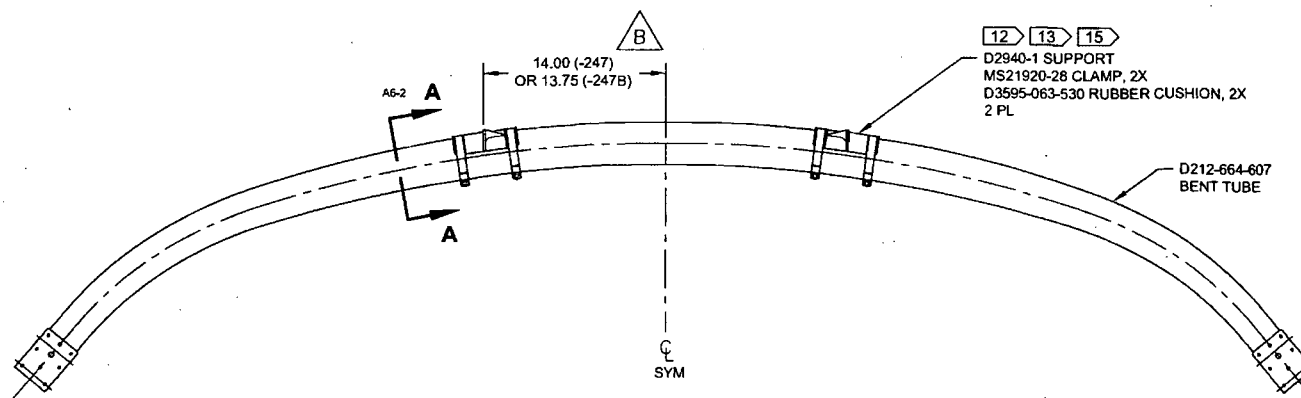
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

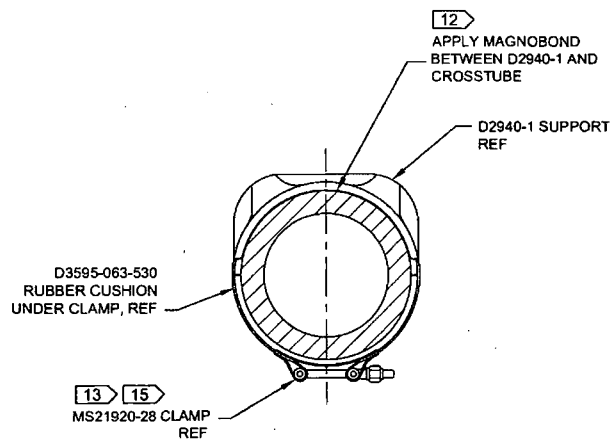
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D212-664-247/-247B  
ASSEMBLY DETAIL**



**SECTION A-A** D6-2  
SCALE 4X

u1070804

UNDER REVIEW

11.06.13

**RELEASED**  
2009-10-29

DESIGN	97	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D212-664-247	SHEET 2 OF 4
APPROVED	97	TITLE	SCALE
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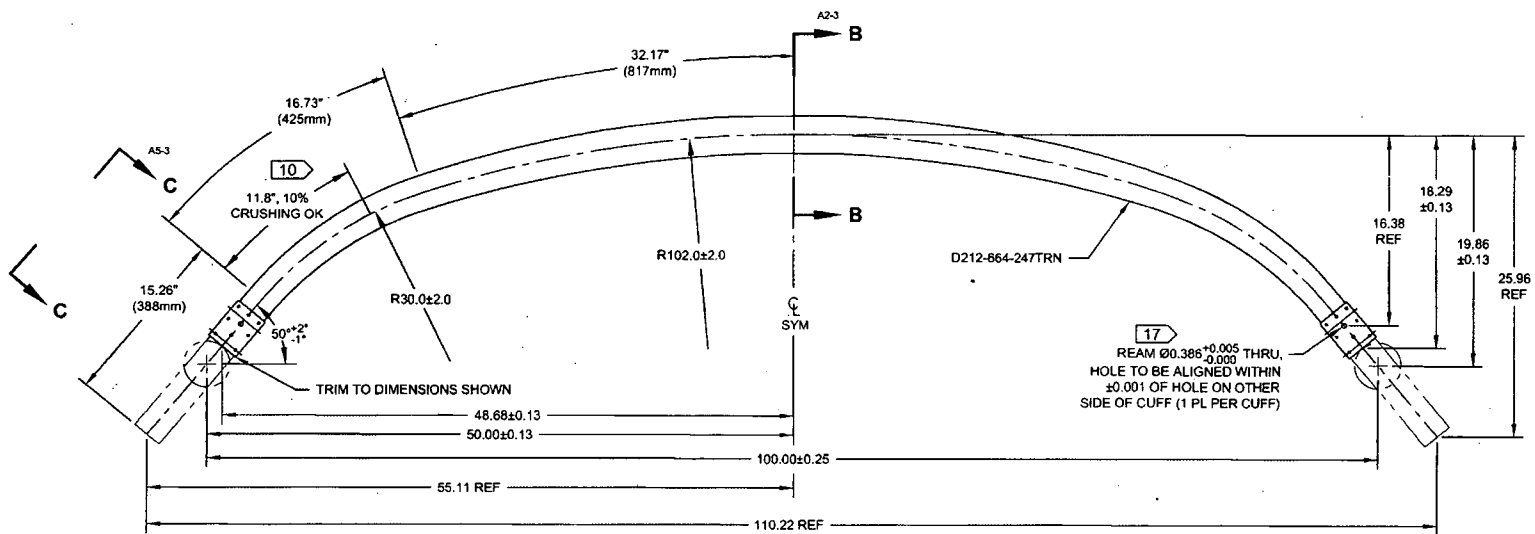
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

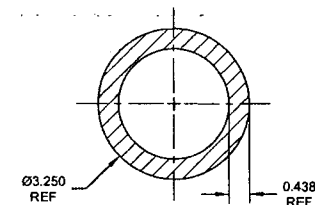
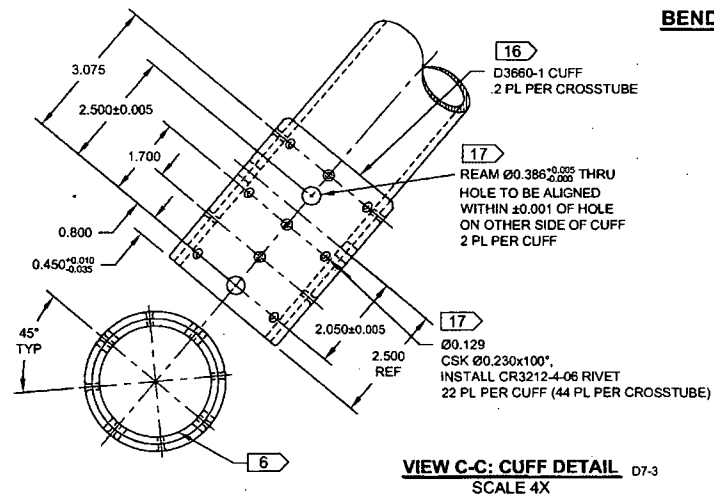
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**D212-664-607**  
**BENDING AND DRILLING DETAIL**



**SECTION B-B** D4-3  
SCALE 4X

UNDER REVIEW

RELEASED  
2009-10-29

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D212-664-247	SHEET 3 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE (205/212 LOW AFT)	NTS
DE APPR.	RF	DATE	09.09.30

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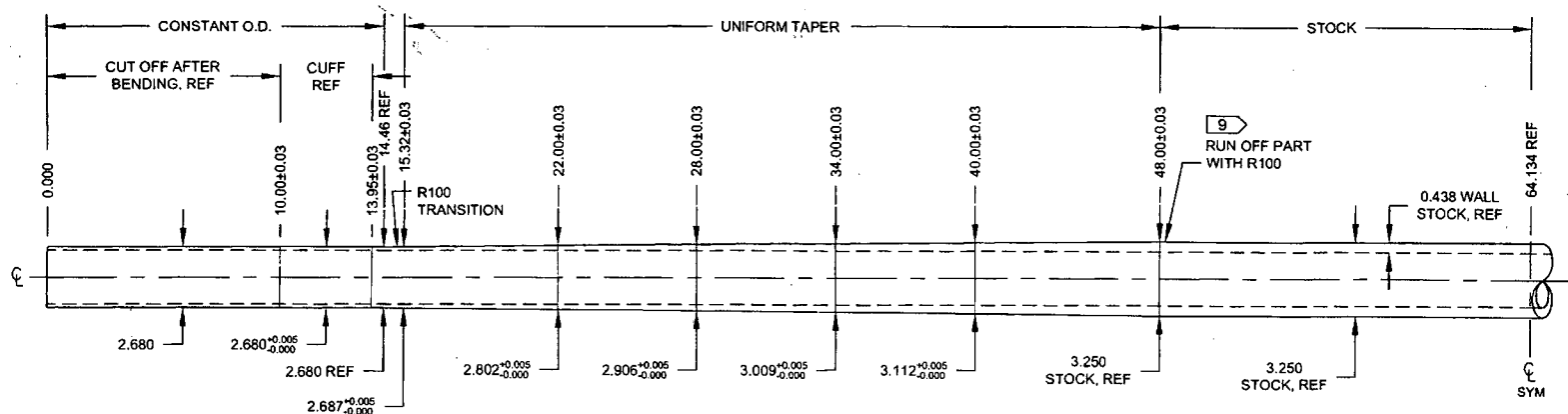
8 7 6 5 4

D

C

B

A



**D212-664-247TRN**  
**TURNING DETAIL**

wb 70804

OK 11-06-16  
UNDER REVIEW  
UP 11/06/13

**RELEASED**  
2009-10-23  
M

DESIGN	40	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	40	DRAWING NO.	REV. B
MFG. APPR.	40	D212-664-247	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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